



TECHNICAL DATA SHEET

BLACK FLEXY CA

P/N 11200, 50480, 13480, 13419

DESCRIPTION

ICKYSTICKY® RUBBER TOUGHENED CA is specifically formulated to bond various rubbers, metals and plastics for use in difficult environments.

- BLACK RUBBER TOUGHENED
- MEDIUM VISCOSITY
- SUPERIOR GAP FILLING FORMULA
- EXCELLENT RESISTANCE TO PEEL AND SHOCK LOADS
- INCREASED FLEXIBILITY AND PEEL STRENGTH
- ACCELERATE CURE SPEED WITH THE USE OF ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155)
- IDEAL FOR BONDING RUBBERS, MAGNETS, METALS AND PLASTICS



BONDS

RUBBER	NEOPRENE	GLASS	PHENOLIC
FIBREGLASS	CARBON FIBRE	POLYCARBONATE	ALUMINIUM
STEEL	METAL		

BONDING TIMES

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short-time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Steel	60-100 seconds	SBR Rubber	15-25 seconds
Polycarbonate	30 - 80 seconds	Neoprene Rubber	12 - 22 seconds
Phenolics	10-50 seconds	Nitrile Rubber	12 - 22 seconds
Aluminium	10-25 seconds		

PHYSICAL PROPERTIES

Liquid

Composition	Rubber Toughened Ethyl Cyanoacrylate Adhesive
Appearance	Black liquid
Viscosity	300 cps @ 25°C Brookfield LVF

Cured Adhesive

Gap Filling	0.3 mm
Tensile Shear Strength	13-28 n/mm ²
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	150
Dielectric Strength, ASTM D149, v/mil	25
Coefficient of thermal expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1

Shear Strength ASTM D 1002/DIN 53283

Steel	>28 N/mm ²
Neoprene Rubber	>12 N/mm ²
PVC	>6 N/mm ²
Aluminium	>19 N/mm ²
Polycarbonate	>7 N/mm ²
ABS	>7 N/mm ²
SBR Rubber	>10 N/mm ²
Nitrile Rubber	>12 N/mm ²

CHEMICAL RESISTANCE PROPERTIES

Chemical retained	Temp.	% Initial strength	
		500 hours	1000 hours
Isopropanol	22 °C	85	85
Gasoline	22 °C	80	75
Motor Oil	40 °C	90	90
Mineral Spirit	22 °C	90	90

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.

DIRECTIONS FOR USE

TEST ON SCRAP MATERIAL BEFORE USE.

1. Ensure parts are clean and dry.
2. Best results will be achieved with surfaces that have been lightly abraded prior to bonding.
3. Protect clothing and work surfaces. Use in a well-ventilated area.
4. Carefully open bottle while keeping bottle pointed away from face.
5. Apply glue to one surface. Assemble parts and hold together with pressure for 10-30 seconds or until set.
6. If using with ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155) apply to one surface only and apply a thin film of adhesive to the other surface. Bring pieces together immediately. Hold for a few seconds without disturbing joints.
7. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
8. STORE UPRIGHT IN A COOL AREA AWAY FROM SUNLIGHT/HEAT SOURCES

NOTE: Not for use with Teflon, polyethylene, polypropylene, certain silicone rubber types, glass, rear view mirrors or parts that are subjected to great shock or continuous immersion in water. For maximum flexibility, do not use with ICKYSTICKY® CA ACTIVATOR.

CAUTION

EYE IRRITANT. BONDS SKIN & EYES IN SECONDS. Contains ethyl cyanoacrylate. Use with adequate ventilation. Avoid contact with clothing as can cause burn. In case of eye contact, flush with water for 15 minutes; get medical attention for eye or internal contact. To remove from skin, soak in acetone nail polish remover & gently peel adhesive off with fingernail; water exposure will wear off residual adhesive in a few days (do not use polish remover around eye area). KEEP OUT OF REACH OF CHILDREN.



ICKYSTICKY® is a registered trademark of AFC INTERNATIONAL PTY LTD
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